

Aero Design Ltd.**Work Order Control Sheet****Work Order#:** 2017-76 **Date Opened:** 26 April 2017 **Title:** Assembly**Aircraft OEM:** Robinson **Aircraft Model:** R44 **Product Type:** Cargo Basket **Product Model:** RH Standard **Quantity:** 1**Work Order Contents**

Work Order/Build Sheets (Procedures Provided)
Additional Work Sheets (Standard Practice)
Drawings (See List Below)
Parts Distribution Sheet
Sub Component Tags
Completed Certification
Time Sheet (R&D)
Notes

Initial or N/A

JC
N/A
JC
JC
N/A
JC
N/A
N/A

Build Sheet Contents

Tasks Initialled
Dual Inspections Initialled

Initial or N/A

JC
JC

Drawing List

Drawing #	Rev #	Description	Initial or N/A
90610	1	Basket Assembly	JC
90627	1	Placard	JC
84240	0	Lid Brace Installation	JC
84255	2	Handle Installation	JC

Traveller

Install walkway on lid
Install lid on basket body
Re-tap mounting lug holes and install mount lugs
Install handle brackets
Install handle
Install lid prop
Install data plate

Initial or N/A

N/A
JC
JC
JC
JC
JC
JC

Component Completion

Quantity Complete on This Work Order
Quantity Incomplete on This Work Order
Further Processing Required Before Release
Release to Stock as Components

As Instructed

1
0
N/A
N/A

Certification

Form One Completed
Serviceable (Green) Tag Completed
In Process (Yellow) Tag Completed
Unserviceable (Red) Tag Completed
Parts Placed in Stores for Distribution

Initial or N/A

JC
N/A
N/A
N/A
N/A

Additional Documentation

Documentation of a minor change
Non-Conformance Report Required
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

Billing

Local (Aero Design)
Research and Development
Third Party

Initial or N/A

JC
N/A
N/A

Work performed by:

Print: J. Clarke

Sign: 

SCA: AD02

Date: 28-Apr-17

ICC / Dual Inspection performed by:

Print: J. Rekve

Sign: 

SCA: AD01

Date: 01-May-17

Work Order closed by:

Print: J. Clarke

Sign: 

SCA: AD02

Date: 02-May-17

Approved Manufacturing Facility 73-04

Form 20.0 03

Rev. Original 23 Sep 2014



Aero Design Ltd.

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AMF 73-04

Nomenclature: BASKET LID (R44 RH) No. of pieces: 1

Manufacturer: AERO DESIGN LTD.

Part No.: 90612-01-01 Serial No.: NSN

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2016-92

Remaining Tasks to be Performed: NONE

Signature: JH Cels.

Date: 06 APR 2017 Lic. No. / SCA AD002

Serviceable



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Remarks



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AMF 73-04

Nomenclature: BASKET BODY (R44 RH) No. of pieces: 1

Manufacturer: AERO DESIGN LTD.

Part No.: 90611-01-01 Serial No.: NSN

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2016-92

Remaining Tasks to be Performed: NONE

Signature: goff C.R.H.

Date: 06 APR 2017

Lic. No. / SCA A002



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AMF 73-04

Serviceable

Remarks

CARGO BASKET HANDLE ASSEMBLY

General

These instructions apply to all cargo basket handle assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

All Models: 84261, Rev. 1

Work Order: 2017-76

Date Open: 28 April 2017

Complete
(initial or SCA #)

AD
73-04 KB
02

1. Fabricate Handle Assembly

- Temporarily install handle levers on lid assembly. Ensure long side of handle bushings are on INSIDE (pointing together).
- Measure across TOP side of levers.
- Cut handle tubing to length measured.
 - Handles under 40" long: 1.0" x 0.035 round tube
 - Handles over 40" long: 1.0" x 0.065 round tube
- De-burr tube.
- Insert tube into handle levers. Tap with a plastic mallet to seat tube flush with lever. Raise handle to ensure both levers touch stops to check alignment.
- Record material PO on attached material list.

2. Weld Handle Assembly

- Fuse tube to lever on both ends. Ensure levers are parallel.

3. Clean up

- Clean welded area with scotch-brite.

4. Final Inspection

- Welds for complete and handle for fit.
- Tag complete and inspected parts in preparation for installation.

AD
73-04
05

AD
73-04 KB
02

AD
73-04
02

Work Order: 2017-76Date Opened: 28 April 2017Material Tracking Sheet
Robinson R44
Handle Assembly

1 of 1

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	<u>1</u>	84261	84261-01	Handle Assembly		
Step 1				<i>Weld Lever Assembly</i>		<u>2017-65</u>
	. 2		84265-01	Lever	304 Stainless, 0.105 Sheet	
	. 2		36274-01	Bushing	304 Stainless, 7/16" x 0.065 Rnd. Tube	
	. 2		MS20615-4M3	Rivet		
	. A/R			Welding Rod	ER308L TIG Rod	
Step 2				<i>Clean Up</i>	<i>None</i>	
Step 3				<i>Fabricate Handle Bar</i>		
	. 1		36277-01	Handle Bar	304 Stainless, 1.0 x 0.035 Rnd. Tube	<u>15073</u>
Step 4				<i>Weld Handle Assembly</i>	<i>None - Fuse weld, no rod req.</i>	
Step 5				<i>Clean Up</i>	<i>None</i>	
Step 6				<i>Inspection - Final Assembly</i>	<i>None</i>	

2017-76

R44 RH Black

General

These instructions apply to all cargo basket assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

Bell 206L/407 – Right side only

69810, Revision 3 – Standard Low Mounted Basket
 94510, Revision 0 – Extra-Wide Low Mounted Basket
 94610, Revision 0 – Extra-Wide Low Mounted Ski Basket
 76610, Revision 0 – High Mounted Ski Basket

Eurocopter AS350/AS355 – left or right

77610, Revision 1 – Short Basket
 76410, Revision 3 – Medium Basket (left or right)
 78410, Revision 2 – Long Basket
 94010, Revision 0 – Extra Large (ski) Basket

Robinson R44 – left or right

90610, Revision 0 – Standard Basket (left or right)

Bell 206B – right side only

80210, Revision 0 – Short Basket
 80310, Revision 0 – Medium Basket
 81110, Revision 0 – Long Basket

Bell 429 – right or left

95911, Revision 0 – Standard Basket

Bell Medium – left or right

75111, Revision 0 – Standard Basket
 95511, Revision 0 – Extra Large (ski) Basket

MD600

82811, Revision 0 – Standard Basket

Options

70405, Revision 3? – Lid Walkway

CARGO BASKET ASSEMBLY - COMMON

Complete
(initial or SCA #)

Work Order: 2017-76

Date Open: 26 APR 2017

AD
73-04
02 KB

1. Lid Assembly

- a. Install lid bumpers on bottom.
 - i. Fill bumper holes with RTV silicone sealant.
 - ii. Insert 49205-14 lid bumper, 3 or 4 places per lid.
- b. Install placard on bracket on top of lid.
 - i. Locate placard on bracket.
 - ii. Drill #30 through placard and bracket, using holes in placard.
 - iii. Remove placard and de-burr holes in placard and on bracket.
 - iv. Locate placard on bracket, and cleco in place.
 - v. Rivet placard with four CR3213-4-02 CherryMax rivets.
- c. Option: Install walkway on top of lid (lid must be fitted with walkway provisions) *N/A*
 - i. Note: avoid touching surface of tread plate with bare hands to prevent smudges or marks on the top surface.
 - ii. Pull tread plate from stock. Shear tread plate to length.
 - iii. De-burr edges of tread plate with scotch-brite disc on die-grinder.
 - iv. Locate tread plate on lid. Hold tread plate in place with bags of lead shot.
 - v. Mark and drill #30 holes:
 1. 0.25" from edge of tread plate, centre on cross members (0.38")
 2. 0.25" from edge of tread plate, middle of each walkway stringer
 - vi. De-burr and counter-bore (if required to provide clearance of rivet head on checker pattern) all holes in tread plate using 1/4" piloted counter bore on both sides.
 - vii. De-burr holes in lid tubes.
 - viii. Apply bead of RTV silicone sealant along all tubes under tread plate.
 - ix. Set tread plate in place, secure with clecos if necessary.
 - x. Rivet placard with CR3213-4-02 CherryMax rivets
- d. Record PO/WO of all parts (including lid) used in steps above on attached material tracking list.

2. Body Assembly

- a. Install attachment fittings
 - i. Carefully remove excess powder coat from around attachment lug threads using a countersink.
 - ii. Run 3/8-24 tap into attachment lugs to clear threads.
 - iii. Apply anti-seize compound to attachment fittings 96710-01 (alternate: Ancra 40088-14)
 - iv. Install attachment fittings with two NAS1149F0363P washers in four lugs in basket.
 1. 90610 (Robinson R44) basket only:
 - a. Install 1 fitting 906?? in lower forward attachment lug only.
 - b. Install 3 96710-01 fittings in remaining locations.
 - v. Torque to ??

AD
73-04
02 KB

CARGO BASKET ASSEMBLY - COMMON

Complete
(initial or SCA #)

- b. 946 Basket Only: Install Cutout Brace – *must be completed after hinge installation*
 - i. Locate 94621-01 Brace over aft cross tube cutout
 - ii. Install two AN4-6A bolts and two AN4-30A bolts with NAS1149F0463P washers.
 - iii. Torque AN4 bolts to ??
- c. Record PO/WO of all parts (including basket) used in steps above on attached material tracking list.

AD
73-04 *top*
02

3. Hinge Installation

- a. Prepare hinge.
 - i. Cut hinge to length:
 - 1. 776, 906 – 54" *jk.*
 - 2. 751, 803 – 70"
 - 3. 698, 764, 945 – 72"
 - 4. 784 – 90"
 - 5. 940, 946, 959 – 95"
 - ii. Drill #30 pilot holes using hinge jig. For long hinges, flip at specified location on jig. *jk.*
- b. Install hinge on basket
 - i. Locate hinge on basket (standard baskets)
 - 1. centre fore/aft
 - 2. 0.15" – 0.18" up from bottom edge
 - ii. Locate hinge on basket (extra wide baskets)
 - 1. centre fore/aft
 - 2. set hinge at 90 degrees (as if lid would be installed) using a small square, locate vertical side at 22.5" from outboard edge.
 - iii. Drill #30 through holes in hinge into basket rim. Cleco in place with 1/8 (copper) clecos.
 - iv. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 (black) clecos.
 - v. Remove hinge and de-burr holes in hinge and basket rim.
 - vi. Cleco hinge to basket with 5/32 clecos.
 - vii. Install hinge with CherryMax rivets
 - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
 - 2. CR3213-5-02 aluminum rivets – all other locations
- c. Install lid on basket
 - i. Locate lid on hinge (all baskets)
 - 1. center fore/aft
 - 2. 0.15" – 0.18" down from top edge
 - ii. Drill #30 through holes in hinge into lid rim. Cleco in place with 1/8 clecos.
 - iii. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 clecos.
 - iv. Remove hinge and de-burr holes in hinge and lid rim.
 - v. Cleco lid to hinge with 5/32 clecos.
 - vi. Install hinge with CherryMax rivets
 - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
 - 2. CR3213-5-02 aluminum rivets – all other locations

CARGO BASKET ASSEMBLY - COMMON

Complete
(initial or SCA #)

- d. Record PO of hinge and rivets on attached material tracking list.

ND
73-04
02 — KB

4. Install Handle

a. Install handle brackets.

- i. Set 84267-01 handle bracket on provisions in hoops, 2 places.
- ii. Install AN3-11A bolt, NAS1149F0363P washer (2), MS21044N3 nut. Two places per bracket, two brackets per basket.
- iii. Torque AN3 bolts to ??.

b. Install handle

- i. Trim 36278-01R and 36278-01L springs to ensure end of spring does not extend past edge of handle bracket, approximately 1/8". Set springs over bushing of 84261-01 handle assembly.
- ii. Grease two 36275-01 bushings with ??. Insert into bushings of handle assembly.
- iii. Locate handle on basket lid. Insert AN3-12A bolt with NAS1149F0363P through bracket on lid and handle bushing on one end of handle.
- iv. On other end of handle, hook spring over catch rivet on handle assembly and use spring tool to twist spring to catch arm on bracket on lid while inserting AN3-12A bolt with NAS1149F0363P washer through lid bracket and handle bushing.
- v. At first end, remove bolt and repeat step iv.
- vi. Install NAS1149F0363P washer and MS21044N3 nut on both AN3-12A bolts.
- vii. Torque AN3 bolts to ??.

c. Check handle

- i. Operate handle to ensure handle does not bind and springs hold handle in.
- ii. Snap handle into brackets to ensure handle locks.

- d. Record PO/WO of all parts used in steps above on attached material tracking list.

ND
73-04
02 — KB

5. Install lid brace

- a. Locate 36280-01 lid brace on bushing in basket. Ensure brace is on forward end of basket as it will be installed on the helicopter.
- b. On lid end, insert AN970-3 washer into end of lid brace. Insert AN3-15A bolt with NAS1149F0363P washer through AN970-3 washer, lid prop, and lid bushing. Install NAS1149F0363P washer and MS21044N3 nut on bolt.
- c. On basket end, insert AN3-17A bolt with AN970-3 washer through lid prop and basket bushing. Install NAS1149F0363P washer and MS21044N3 nut on bolt.
- d. Ensure brace is seated on lip of bushings before tightening nuts.
- e. Torque AN3 bolts to ??
- f. Record PO/WO of all parts used in steps above on attached material tracking list.

CARGO BASKET ASSEMBLY - COMMON

Complete
(initial or SCA #)

OK

6. Final Inspection

Dual inspection by a different person than assembled the basket.

- a. Check for general condition and correct assembly:
 - i. Bolts are tight
 - ii. Rivets are installed correctly
 - iii. Handle operates correctly
 - iv. Lid brace operates correctly
- b. Check that PO/WO numbers have been recorded.

Work Order: 2017-76Material Tracking Sheet
Robinson R44
Basket Assembly

1 of 2

Date Opened: 26 Apr 2017

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/NO
	1		90610-01- 01	Cargo Basket Assembly	(-01 RH, -02 LH)	
Step 1				<i>Lid Assembly</i>		
	1		90612-01- 01	Basket Lid Assembly		2016-92
Step 1.a.	3		49205-14	Bumper	Argus Industries Bumper	
	A/R		--	Sealant	Commercial Silicone RTV sealant	
Step 1.b.	1		90627-01	Placard	0.063 Sheet, 6061-T6 Aluminum	2015-03
	4		CR3213-4-02	Cherry Rivet		16053
Step 2				<i>Basket Assembly</i>		
Step 2.a.	1		90611-01- 01	Basket Body Assembly		2016-92
	3		96710-01	Fitting	Alternate: Ancra 40088-14	
	1		90628-01	Fitting		11105
	8		NAS1149F0663P	Washer		
Step 3				<i>Hinge Installation</i>		
	1		MS20001P4	Piano Hinge	54"	16030
	8		CR3523-5-02	Cherry Rivet		16063
	A/R		CR3213-5-02	Cherry Rivet		16053
Step 4	1	84255	84255-01	<i>Handle Installation</i>		
Step 4.a.	2		84267-01	Bracket	Delrin, 3/4" Sheet	2017-50
	4		AN3-11A	Bolt		
	8		NAS1149F0363P	Washer		
	4		MS21044N3	Nut		
Step 4.b.	1		84261-01	Handle Assembly		2017-76
	2		36278-01	Spring (1 left, 1 right)	304 Stainless, 1/16" Dia Music Wire	
	2		36275-01	Bushing	Brass, 5/16" Dia	
	2		AN3-12A	Bolt		
	4		NAS1149F0363P	Washer		
	2		MS21044N3	Nut		

Work Order: 2017-76Date Opened: 26 APR 2017Material Tracking Sheet
Robinson R44
Basket Assembly

2 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 5				<i>Lid Brace Installation</i>		
	. 1		36280-01	Brace Assembly		2017-38
	. 1		AN3-15A	Bolt		
	. 1		AN3-17A	Bolt		
	. 2		AN970-3	Washer		
	. 3		NAS1149F0363P	Washer		
	. 2		MS21044N3	Nut		
Step 6				<i>Inspection</i>	None	



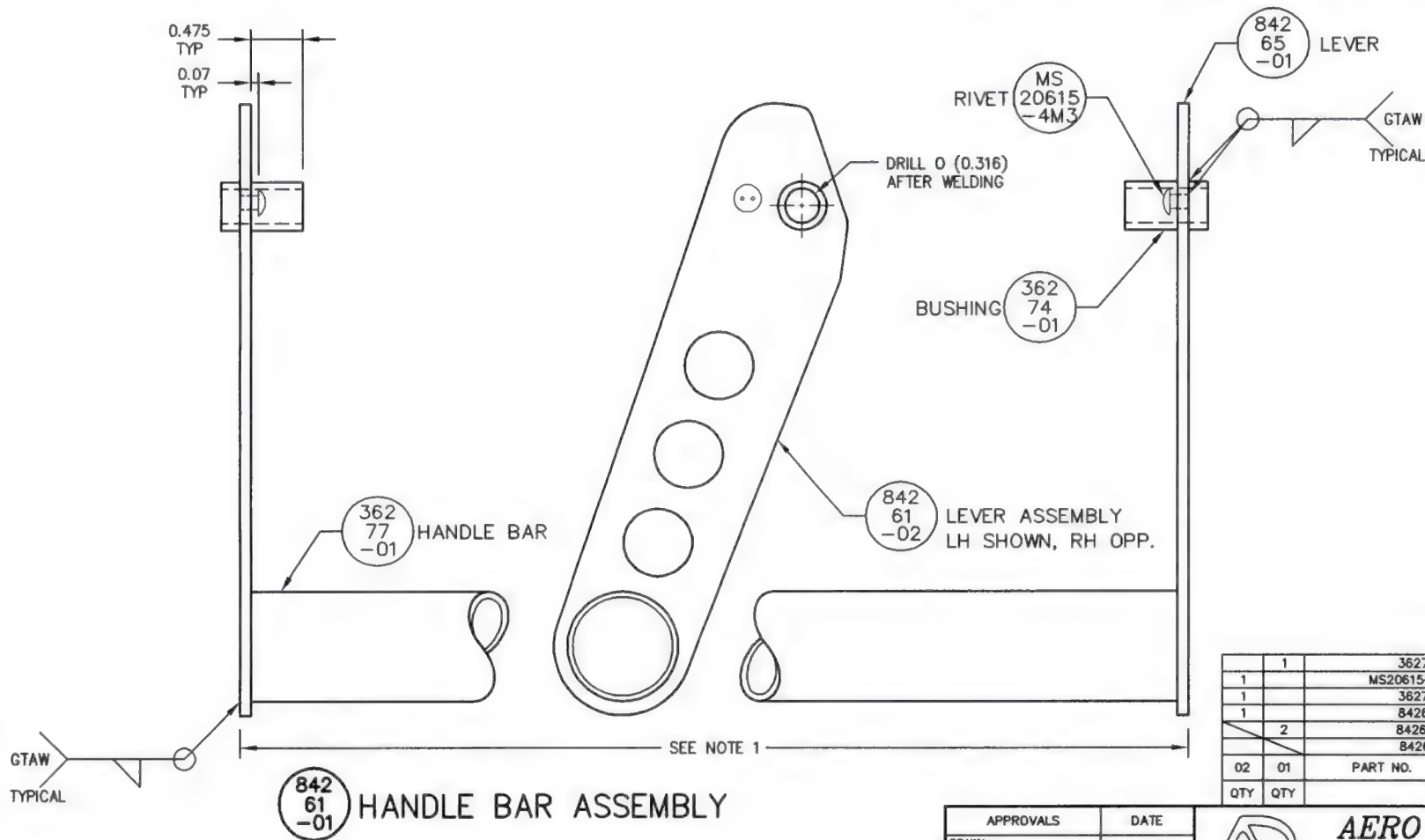
WO#

Approved Manufacturing Facility 73-04

Rev. Original 27 May 2013

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	HANDLE END BRACKETS FLIPPED	BJC	SEPT 19/11
2	TITLE BLOCK UPDATED; LEVER ASSEMBLY ASSIGNED P/N	BJC	MAR 13/14



1	36277-01	HANDLE BAR
1	MS20615-4M3	RIVET (MONEL)
1	36274-01	BUSHING
1	84265-01	LEVER
2	84261-02	LEVER ASSEMBLY (RH/LH)
2	84261-01	HANDLE BAR ASSY
02	01	PART NO.
QTY	QTY	LIST OF MATERIALS

NOTES:

1. LENGTH OF HANDLE TO BE DETERMINED BY BASKET ASSEMBLY DRAWING.
2. REMOVE ALL BURRS AND SHARP EDGES.
3. WELDING TO BE COMPLETED BY GTAW METHOD TO AMS2685C USING ER308L ROD.

APPROVALS	DATE
DRAWN: R. RATHWELL	JUNE 18/09
CHECKED: E. BURGAIN	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:	
DECIMALS	ANGLES
X.XXX ±0.010	±1/2°
X.XX ±0.03	
X.X ±0.1	

 AERO DESIGN LTD. 9888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 604.483.2376 www.aerodesign.ca		HELICOPTER CARGO BASKET HANDLE BAR ASSEMBLY	
		SCALE 1 : 1	REV. 2
SHEET 1 OF 1	DWG. SIZE A3	DWG. NO. 84261	



Aero Design Ltd.

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Nomenclature: Handless R44 AMF 73-04
No. of pieces: 1
Manufacturer: Aero Design Ltd.
Part No.: 84261 Rev. 1 Serial/Batch No.: NA
TTSN: NA TSO: NA Rem.: NA
Work Order No.: 2017-76
Remaining Tasks to be Performed: Instal

Signature: David Pessier
Date: April 28 / 2017 Lic. No. / SCA AD-05



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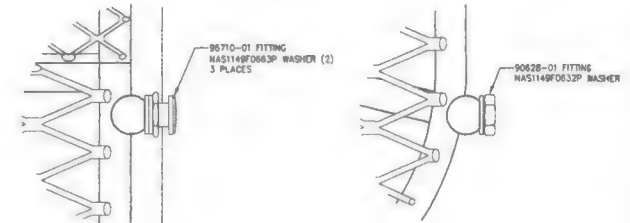
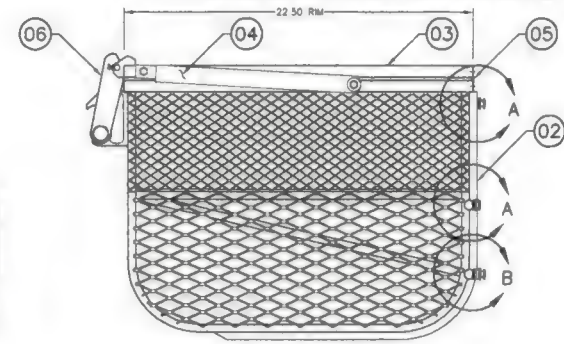
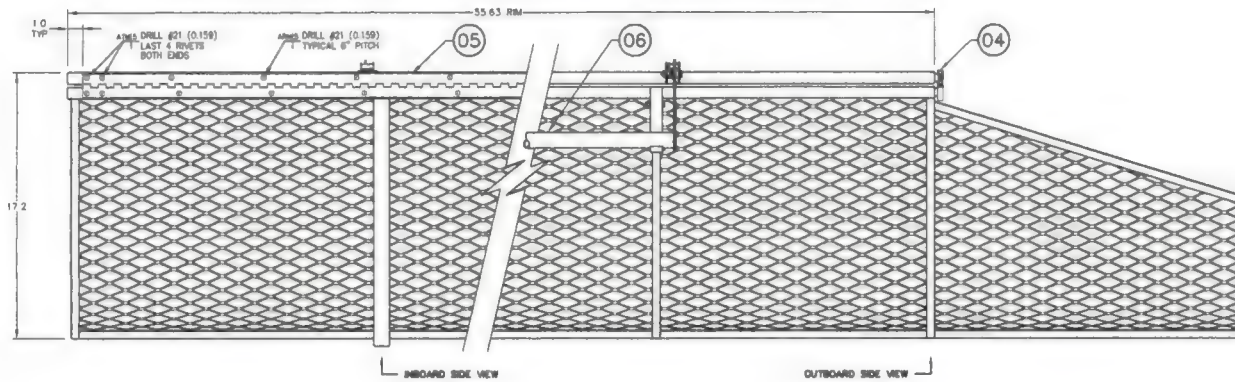
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AMF 73-04

Serviceable

Remarks

DESCRIPTION OF CHANGE		INITIALS	DATE
REV	0		
TITLE BLOCK UPDATED, HINGE LENGTH INCREASED, WASHER P/N'S UPDATED, ADD ALTERNATE RIVETS, CHANGE BRACE ASSEMBLY TO INSTALLATION		BJC	21/05/2014



DETAIL A

SCALE 1 : 1
FRONT TOP AND REAR TOP AND BOTTOM POSITIONS

DETAIL B

SCALE 1 : 1
FRONT BOTTOM POSITION ONLY

NOTE

1 ALL DIMENSIONS SHOWN ARE FOR REFERENCE ONLY. DIMENSIONS OF COMPONENTS AND COMPLETE ASSEMBLY ARE DETERMINED IN PREVIOUS STEPS.

QTY	PART NO	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
1	90627-02	07	PLACARD			
1	90627-01	07	PLACARD			
1	84255-01	06	HANDLE BAR INSTALLATION			
1	MS20001F4	03	FRANG HINGE			34 0 LONG
1	84240-01	04	LID PROP INSTALLATION			
1	90612-01-02	03	BASKET LID ASSEMBLY (LEFT HAND)			
1	90612-01-01	03	BASKET LID ASSEMBLY (RIGHT HAND)			
1	90611-01-02	02	BASKET BODY ASSEMBLY (LEFT HAND)			
1	90611-01-01	02	BASKET BODY ASSEMBLY (RIGHT HAND)			
1	90610-01-02	01	CARGO BASKET ASSEMBLY (LEFT HAND)			
1	90610-01-01	01	CARGO BASKET ASSEMBLY (RIGHT HAND)			
-02	-01					

LIST OF MATERIALS

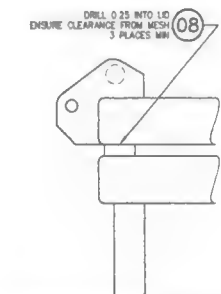
BASIC CODE	DASH NO. FOR DIAMETER	APPROVALS	DATE
REF: NAS 323	N=MFTD HEAD NEAR SIDE F=MFTD HEAD FAR SIDE	JEFF CLARKE	13 SEPT 2010
C=COUNTERSINK	DASH NO. FOR LENGTH	CHECKED	
D=DIAMETER		E BURGIN	
DIOT=8 OF SHEETS TO BE DIMPLED			
BASIC CODES:			
BJ = MS20470AD			
BB = MS20428AD			
ARW = CR3213			
ATW = CR3523			

AERO DESIGN LTD.			
9000A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 844 463 8378 www.aerodesign.ca			
ROBINSON R44, R44 II QUICK RELEASE CARGO BASKET CARGO BASKET ASSEMBLY			
SCALE 1 : 4	DWG SIZE	DWG NO	REV
SHEET 1 OF 1	A1	90610	1



DETAIL C

SCALE 1 : 1
LOOKING AT PLACARD BRACKET



BUMPER INSTALLATION
SCALE 1 : 1

01 CARGO BASKET ASSEMBLY
RIGHT HAND SHOWN, LEFT HAND OPPOSITE

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	TITLE BLOCK UPDATED; ADDRESS AND LOGO UPDATED	BJC	21/05/2014

NOTES

- ENGRAVE 0.007 DEEP AS FOLLOWS:
"QUICK RELEASE BASKET" - 0.125 HIGH
"ROBINSON R44 SERIES" - 0.080 HIGH
"S/N 90601-XX" - 0.080 HIGH
"MAXIMUM PERMISSIBLE LOAD" - 0.125 HIGH
"175 LBS/80 KG" - 0.200 HIGH
"AERO DESIGN LTD." - 0.125 HIGH
"POWELL RIVER, BC, CANADA" - 0.080 HIGH
"www.aerodesign.ca" - 0.080 HIGH


- ON 90627-02: S/N IS 90602-XX.

DRILL #30 (0.129)
4 PLACES



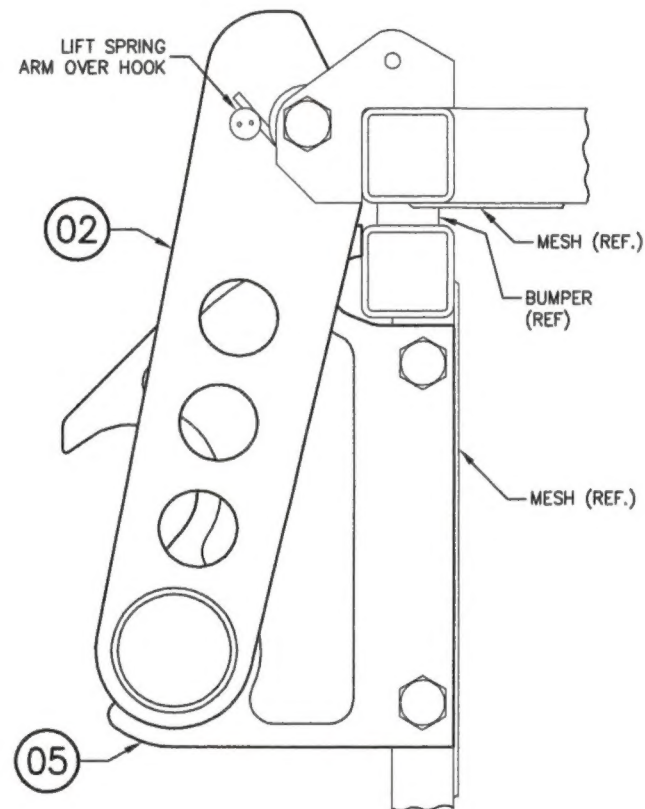
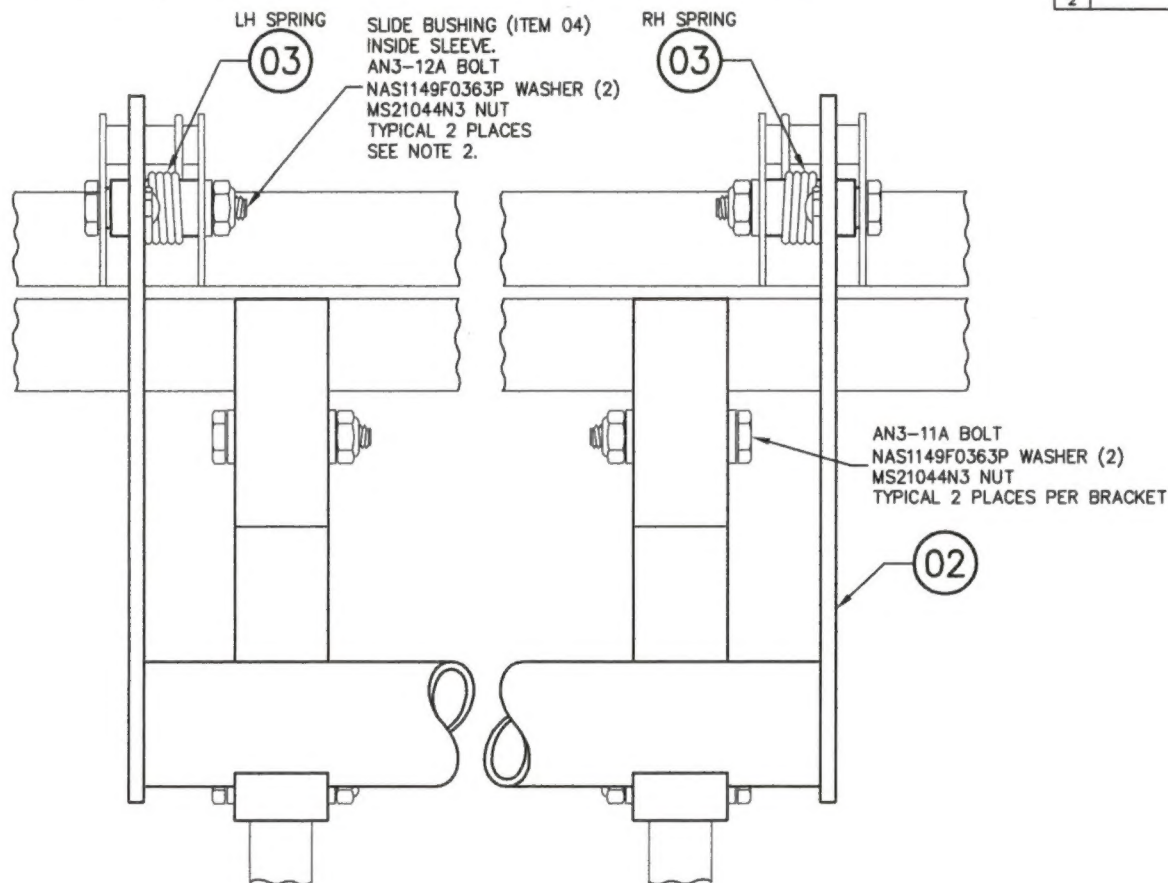
01 PLACARD
02 PLACARD

90627-02	02	PLACARD (LH BASKET)	6061-T6 ALUMINUM	QQ-A-250/11	0.063 SHEET
90627-01	01	PLACARD (RH BASKET)	6061-T6 ALUMINUM	QQ-A-250/11	0.063 SHEET
PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
LIST OF MATERIALS					

THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING, OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DUPLICATED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECEPT AGREEES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREON.	APPROVALS DRAWN: JEFF CLARKE CHECKED: E. BURGAIN	DATE 13 SEPT 2010	 AERO DESIGN LTD. 9888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 604.483.2376 www.aerodesign.ca	ROBINSON R44, R44 II QUICK RELEASE CARGO BASKET PLACARD							
	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2" X.XX ±0.03 X.X ±0.1							SCALE 1 : 1 SHEET 1 OF 1	DWG. SIZE A4	DWG. NO. 90627	REV. 1

NOTES:

1. THIS DRAWING IS AN ALTERNATE CONFIGURATION FOR THE HANDLE INSTALLATION SHOWN ON DRAWING 36255.
2. GREASE BUSHING (ITEM 04) USING MOBILGREASE 28 OR EQUIVALENT PRIOR TO INSTALLATION.



01 HANDLE INSTALLATION

A/R	MOBILGREASE 28		GREASE	MIL-PRF-81322F
4	AN3-11A		BOLT	
2	AN3-12A		BOLT	
10	NAS1149F0363P		WASHER	
6	MS21044N3		NUT	
2	84267-01	05	BRACKET	
2	36275-01	04	BUSHING	
2	36278-01	03	SPRING (1 LH, 1 RH)	
1	84261-01	02	HANDLE BAR ASSEMBLY	
	84255-01	01	HANDLE INSTALLATION	
01	PART NO.	ITEM	DESCRIPTION	MATERIAL
QTY.	LIST OF MATERIALS			

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE - CREATED FROM 36255	BJC	NOV 03/09
1	HANDLE END BRACKETS FLIPPED	BJC	SEPT 19/11
2	TITLE BLOCK UPDATED; ADD NOTE 2; HARDWARE UPDATED	BJC	MAR 13/14

APPROVALS	DATE
DRAWN: JEFF CLARKE	03 NOV 2009
CHECKED: E. BURGOIN	

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES.
TOLERANCES ON:
DECIMALS ANGLES
X.XXX ±0.010 ±1/2°
X.XX ±0.03
X.X ±0.1



AERO DESIGN LTD.

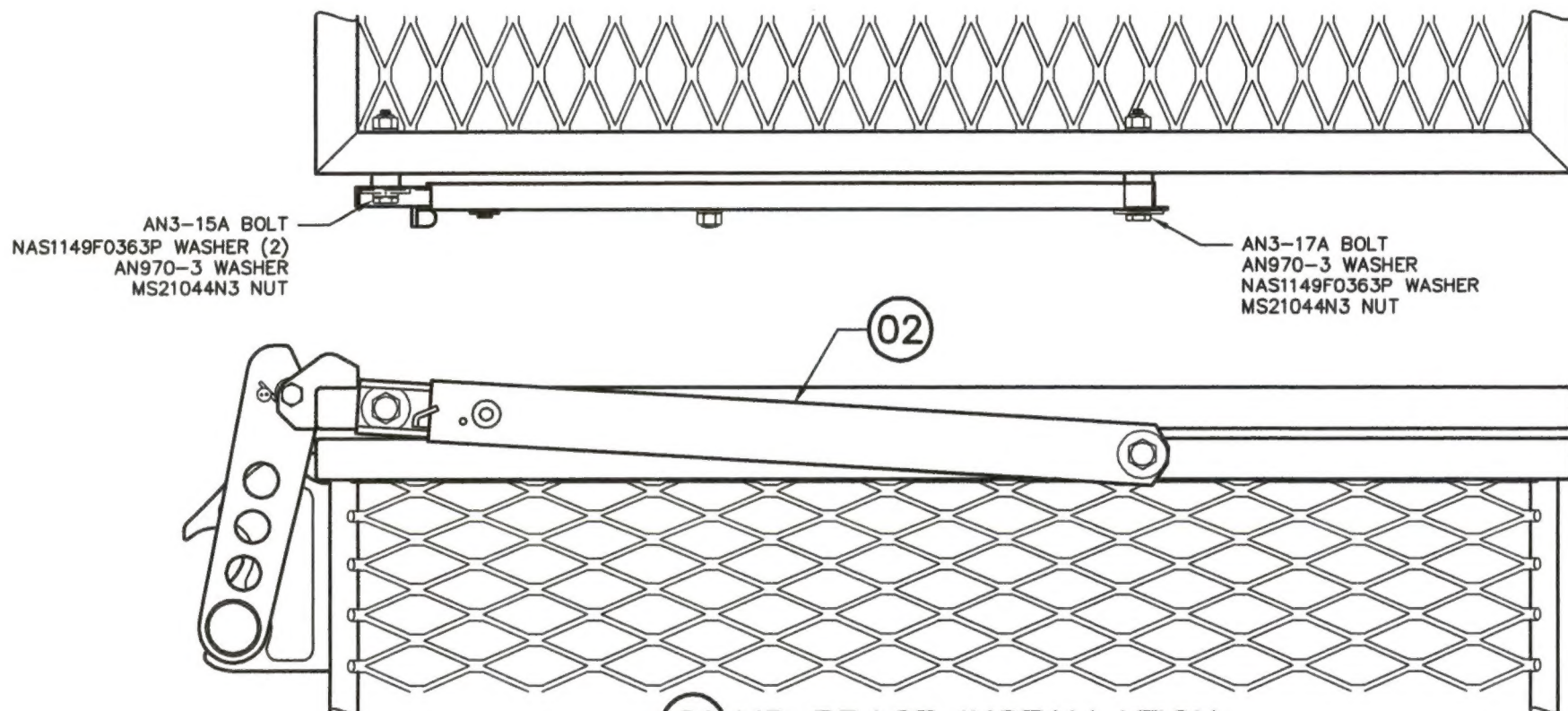
9888A MALASPINA ROAD
POWELL RIVER, BC, CANADA, V8A 0G3
TEL: 804.483.2376 www.aerodesign.ca

HELICOPTER CARGO BASKET
HANDLE BAR INSTALLATION

SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A3	84255	2

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE	*	*



NOTES

- THIS DRAWING APPLIES TO ALL AERO DESIGN LTD. CARGO BASKET ASSEMBLIES.
LID PROP IS TO BE INSTALLED ON THE FORWARD END OF THE BASKET AS INSTALLED ON THE HELICOPTER.

2	MS21044N3		NUT
3	NAS1149F0363P		WASHER
2	AN970-3		WASHER
1	AN3-17A		BOLT
1	AN3-15A		BOLT
1	36280-01	02	LID BRACE ASSEMBLY
	84240-01	01	LID BRACE INSTALLATION
01	PART NO.	ITEM	DESCRIPTION
QTY.	LIST OF MATERIALS		

APPROVALS	DATE
DRAWN: JEFF CLARKE	21 MAY 2014
CHECKED: JASON REKVE	21 MAY 2014
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:	
DECIMALS	ANGLES
X.XXX ±0.010	±1/2°
X.XX ±0.03	
X.X ±0.1	

 AERO DESIGN LTD. 9888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 804.483.2576 www.aerodesign.ca		HELICOPTER CARGO BASKET ALL MODELS LID BRACE INSTALLATION	
NOT TO SCALE	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A4	84240	0

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. 2017-0170
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO2017-76
6. Item	7. Description RH Cargo Basket	8. Part Number 90610-01-01	9. Qty. 1	10. Serial/Batch No. 90601-17	11. Status/Work New
12. Remarks BLACK.					
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12. Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature  73-04 02		13c. Approved Organization Number AMF 73-04		14b. Signature	
13d. Name Jeff Clarke – AD02		13e. Date (dd/mmm/yyyy) 02 May 2017		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mmm/yyyy)	
Installer Responsibilities This certificate does not constitute authority to install. Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified. Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.					

HANK SWAN